

# Work Order ID 86436

June-28-12 1:03:38 PM

**\*86436\***

Page 1

Item ID: D2656-13

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Wearplate

Start Date: 28/06/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 12/07/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/06/28* Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2656	Rev D

100	FLOW WATER JET	0.00
-----	----------------	------

**\*100\***

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2656 Dwg Rev: *D* Prog Rev: *D* 2-  
Deburr if necessary

*1010 1040*

*B12-7-6*

110	QC2- Inspect parts off machine FAI/FAIB	0.00
-----	---	------

**\*110\***

QC

Memo

0.00

Quality Control

*B12-7-6*

120	QC8- Inspect parts - second check	0.00
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**\*120\***

QC

Memo

0.00

Quality Control

*8/2/12*

*(Signature)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

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Page 2

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Revision ID:

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Stop **\*NS2\***

Start Date: 28/06/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 12/07/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

**\*130\***

Brake NC

NC BRAKE

0.00

Memo

0.00

Brake NC

1-Form on Brake as per Dwg D2656 using Jigs DT8261 and DT83262-Form  
joggle as per Dwg D2656 using Jig DT8158 Identify as D2656-13

6

12/07/13

140

**\*140\***

QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

12/07/13

16

150

**\*150\***

Powdercoat

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

8:30

320012

9:00

6x

12/07/16

12/279

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

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**\*NS1\***

Revision ID:

Item Name: Wearplate

Stop

**\*NS2\***

Start Date: 28/06/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 12/07/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00

**\*160\***

QC

Memo

0.00

Quality Control

6x 4 11/10/16

170

Identify as per dwg & Stock Location

0.00

**\*170\***

Packaging

Memo

0.00

Packaging

FP7  
Store

6X 0 12/07/16

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

12/7/18

MCJ 12/07/16

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

June-28-12 1:03:42 PM

Page 1

Work Order ID: 86436

\*86436\*

Parent Item: D2656-13

\*D2656-13\*

Parent Item Name: Wearplate

Start Date: 28/06/2012

Required Date: 12/07/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: F 02.10.25Re-formatKJ/RF  
IPP Rev:G Now on Waterjet 06-07-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S20GA		Purchased	No			100	sf	190.3700	0.85	5.1			

\*M1010S20GA\*

\*\*

B2-7-6

1010/1025 SHEET

Location

Loc Qty

Loc Code

MAT019

190.37

111410

26.9

116791

41.17

121780

122.3

121780

6

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

**Part No:** \_\_\_\_\_ **PAR #:** \_\_\_\_\_ **Fault Category:** \_\_\_\_\_ **NCR: Yes No** **DQA:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**Resolution:** \_\_\_\_\_ **Disposition:** \_\_\_\_\_ **QA: N/C Closed:** \_\_\_\_\_ **Date:** \_\_\_\_\_

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**Dart Aerospace Ltd**

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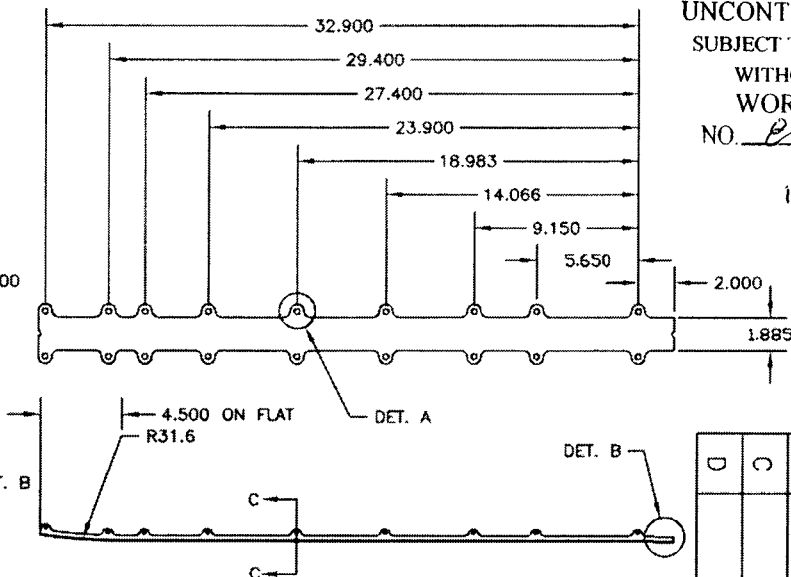
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 20436MLW

12/06/28

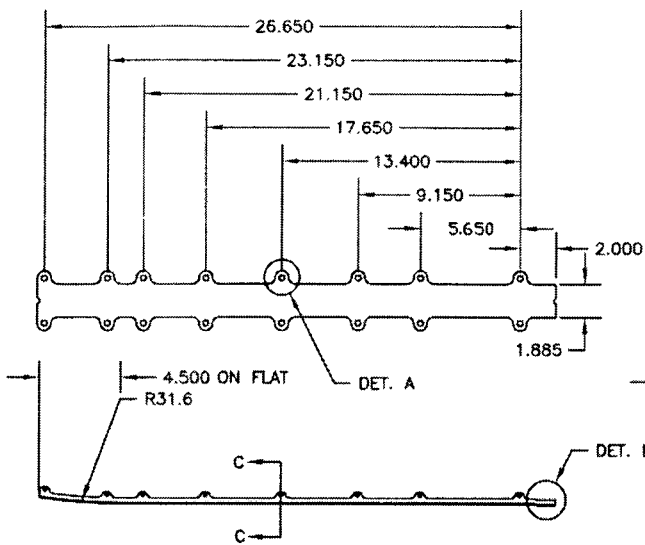


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DS	CP			
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		D2656		
DATE		TITLE		SCALE
05.08.17		WEARSHOE		1:10
A	97:03:25	NEW ISSUE		
B	97:06:02	CHANGED TABS		
C	97:06:26	R31.6 WAS R19.5		
D	05.08.17	ENLARGE ALL HOLES TO IMPROVE FIT		

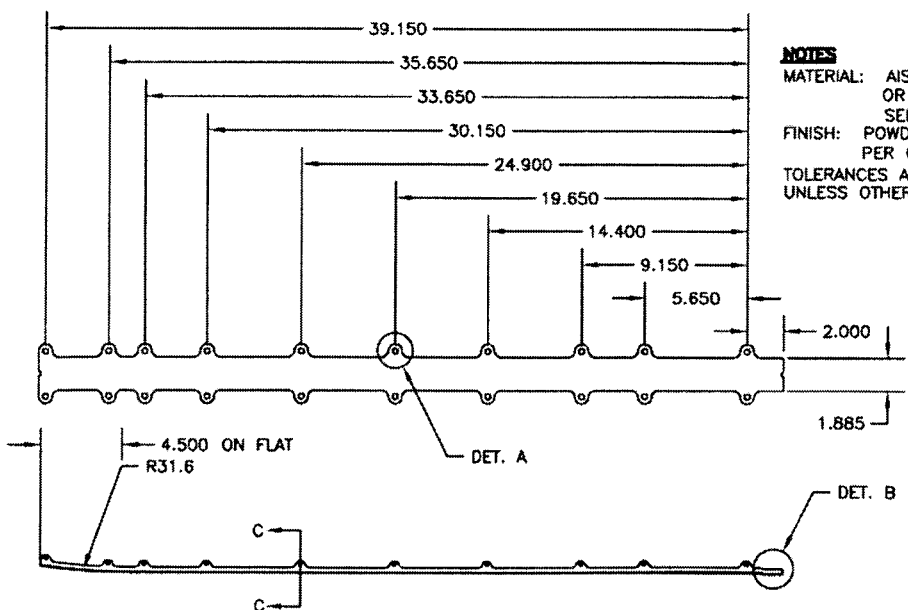
**D2656-13**



**D2656-11**



**D2656-15**



**NOTES**  
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008  
OR CSA G40-21, 38W/44W/50W/60W/70W  
SERIES STEEL 20 GAUGE (0.040 THICK)  
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)  
PER QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED

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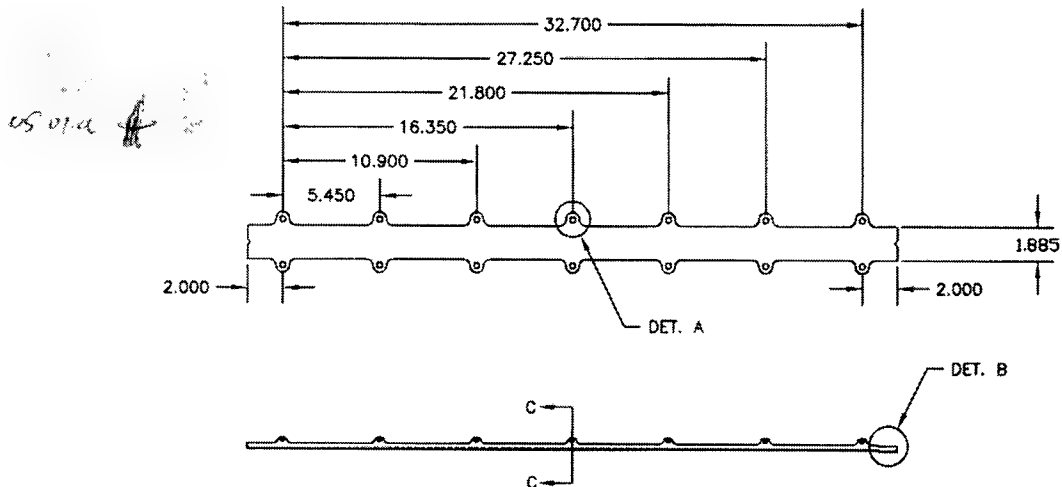
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96436

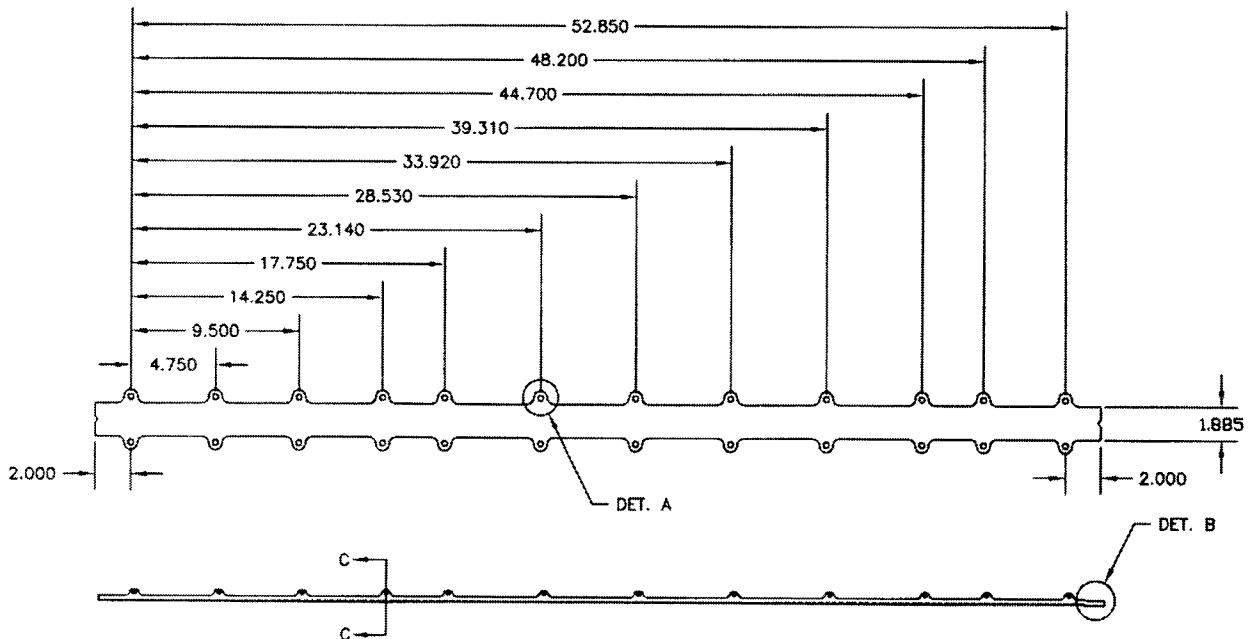


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DATE <b>05.08.17</b>		TITLE <b>WEARSHOE</b>	SCALE 1:10

**D2656-21**



**D2656-23**



**NOTES**

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W  
 SERIES STEEL, 20 GAUGE (0.040 THICK)  
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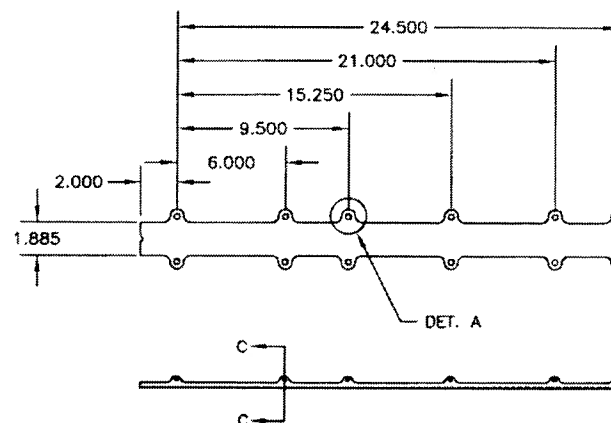
**NOTE:** Date & initial all entries

86436

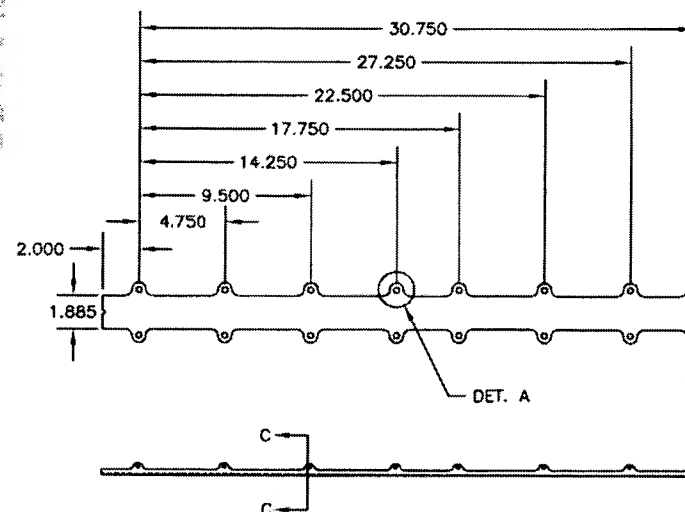


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DATE	05.08.17	TITLE	D2656	WEARSHOE
		SCALE	1:10	
		SHEET 3 OF 4		
		REV. D		

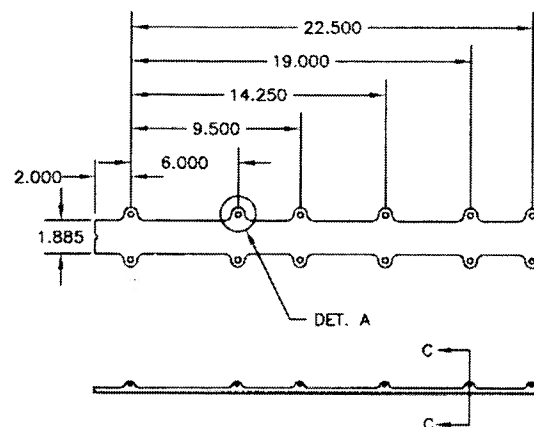
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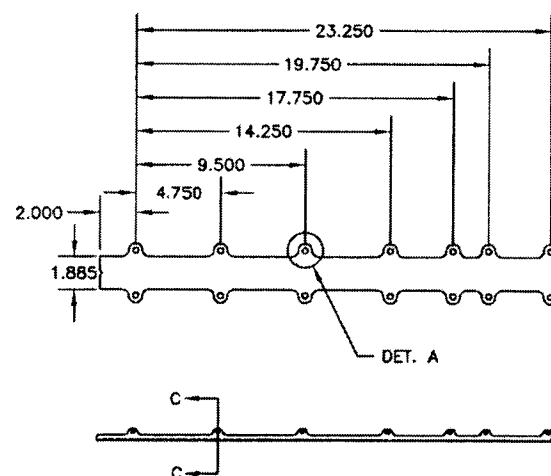
D2656-37



D2656-31



D2656-35



**NOTES**

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W  
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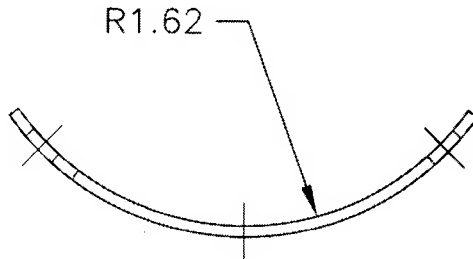


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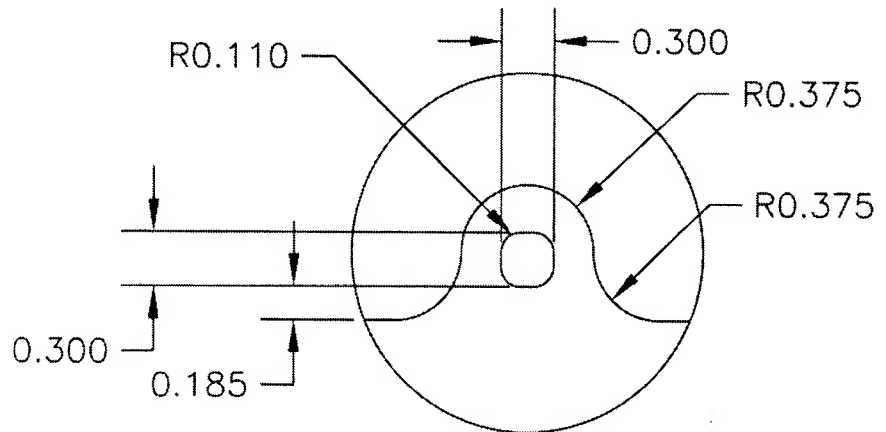
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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

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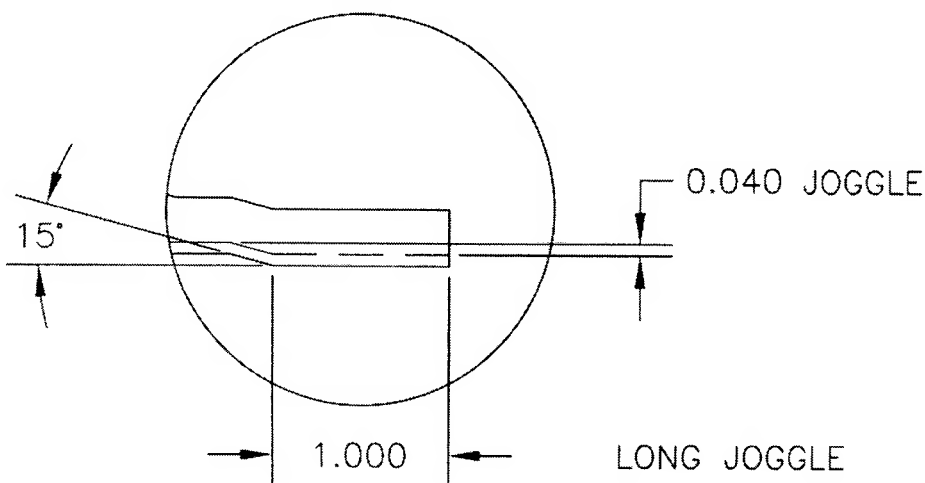


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### DETAIL A



### DETAIL B



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